

Date: Monday, 11/21/2005 7:41:48 PM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 3" OUTER TUBE
Job Number	: 24841		
Estimate Number	: 10796	Part Number	: D26001240
P.O. Number	: N/A	Drawing Number	: D2600 REV D1
This Issue	: 11/21/2005 S.O. No. : N/A	Project Number	: N/A
Prsht Rev.	: NC	Drawing Revision	: D1
First Issue	: N/A Type : PURCHASED PARTS	Material	: N/A
Previous Run	: N/A	Due Date	: 12/15/2005
Written By	: SEE COMMENT BELOW	Qty:	50 Um: Each
Checked & Approved By	: SEE ABOVE USER & DATE		
Comment	: Est Rev:A 99.08.18 Was 2600-1 added -240 for length EC		

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description:

1.0

PG

PURCHASING



Comment: PURCHASING 2008933

Issue P/O: PO 00000713

AR 05/11/25

a) Extrude as per Dwg D2600 (240" long)

b) Material: 6061-T6

c) Tool: MH-18870 OR BOWL #897121

d) Material certification is required.

2.0

D26001240

Extrusion Round 3" 206



Comment: Qty.: 1.0000 Each(s)/Unit Total: 50.0000 Each(s)

Extrusion Round 3" 206

3.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

Ensure material certification is attached

C205112115

59

4.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

5.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: LB

59
 1006-12
 59

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

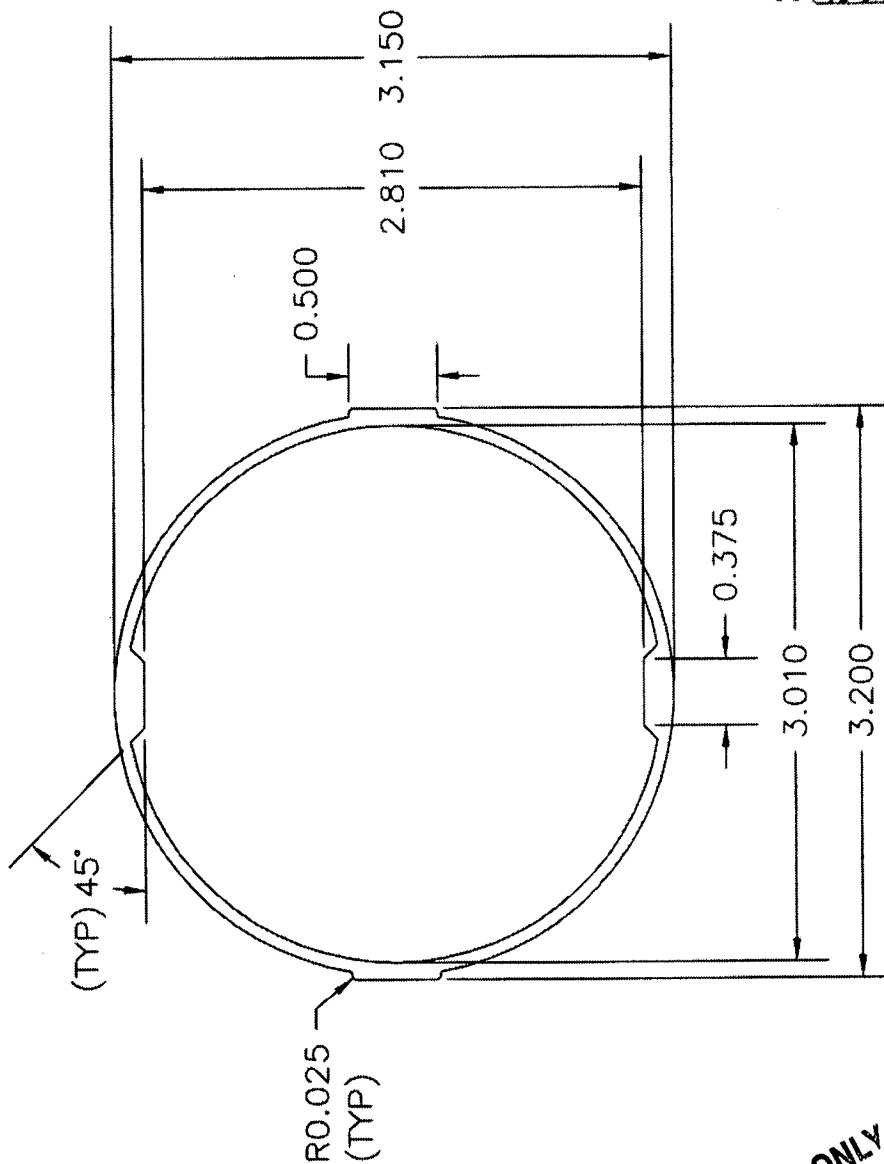
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>KE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2600	REV. D SHEET 2 OF 5
DATE 98.08.20		TITLE EXTRUSION	SCALE 1:1

RELEASED
98.8.25 DS



D2600-1

MANUFACTURED WITH CARADON INDALOX DIE # MH-18870
OR BON L DIE # 897121 (PREFERRED CHOICE)
PART NUMBER IS D2600-1-XXX WHERE XXX IS CUT LENGTH IN INCHES (EG. D2600-1-160 IS 160" LONG)



REFERENCE ONLY



DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>KE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2600	REV. D SHEET 1 OF 5
DATE 98.08.20		TITLE EXTRUSION	SCALE 1:1
A	97.01.21	NEW ISSUE	
B	97.09.09	CHANGE MATERIAL SPEC.	
C	98.04.16	ADD D2600-3, UPDATE D2600-1 WIDTH, ADD DIE NO.	
D	98.08.20	INCREASE MIN. UTS TO 40 KSI	
DI	01.04.17	ADD PART NUMBERS & DIE NUMBERS <i>FCP</i>	

RELEASED
98.08.25 DS

GENERAL NOTES

1. MATERIAL: 6061-T6 (QQ-A-200/8)

MINIMUM YIELD TENSILE STRENGTH = 35 ksi
MINIMUM ULTIMATE TENSILE STRENGTH = 40 ksi
MINIMUM ELONGATION = 8 %

A SAMPLE FROM EACH BATCH WILL BE PULL TESTED TO ASTM STANDARD B221 BY AN APPROVED TESTING FACILITY TO ENSURE THAT THE BATCH MEETS THE ABOVE MINIMUM MECHANICAL PROPERTIES.

2. BREAK ALL SHARP CORNERS 0.010 MAX.
3. NO TOOLING MARKS.
4. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
5. ALL DIMENSIONS ARE IN INCHES.

REFERENCE ONLY

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Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Nov 17, 2005
03:30 pm

Work Order No	: 0024841	Department Code:	
Project Name	: D2600-1-240	Burden Flags	: NNNNNNNN
Project For	: WK550	WO Status	: Open
Work Order Type	: Main	Invoice State	: Not Invoiced
Main WO Number	:	Invoice Date	:
House Part Number	: D2600-1-240	Invoice Number	:
Description	: Extrusion Round 3" 206	Invoice Amount	: 0.00
Manufactured	: Yes		
Amount Req'd	: 50	Order Entry No	:
Amount Done	: 0	OE Value	: 0.00
Start Date	: 11-17-05		
Est Finish Date	: 12-20-05	Est Margin	: 0.000%
Act Finish Date	:	Actual Margin	: 0.000%
Drawings Req'd	: No		
Ok for Approval	:		
Approval Rec'd	:	\$0 Posted to Finished Goods	

	Estimated	Actual	Var. %	Posted	To Post
Material Cost	: 0.00	0.00	0.00	0.00	0.00
Engineering Hours	: 0.00	0.00	0.00		
Engineering Cost	: 0.00	0.00	0.00	0.00	0.00
Production Hours	: 0.00	0.00	0.00		
Production Cost	: 0.00	0.00	0.00	0.00	0.00
Packaging Hours	: 0.00	0.00	0.00		
Packaging Cost	: 0.00	0.00	0.00	0.00	0.00
OverHead Hours	: 0.00	0.00	0.00		
OverHead Cost	: 0.00	0.00	0.00	0.00	0.00
CNC Hours	: 0.00	0.00	0.00		
CNC	: 0.00	0.00	0.00	0.00	0.00
Misc. Hours	: 0.00	0.00	0.00		
Misc.	: 0.00	0.00	0.00	0.00	0.00
Burden	: 0.00	0.00	0.00		
Total Cost	: 0.00	0.00	0.00		
Margin	: 0.000	0.000			
Selling Cost	: 0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done	: 0.00	0.00
Profits/(Loss)	: 0.00	0.00

check BY order

RM NO. B1065 REV. C
RETURN MATERIALS WILL BE ACCEPTED FOR CREDIT WITHOUT PERMISSION
LE MATÉRIEL NE SERA ACCEPTÉ POUR CRÉDIT SANS AUTORISATION



CERTIFICATE OF COMPLIANCE

BON L CANADA INC

500 EDWARD AVENUE
RICHMOND HILL, ON L4C 4Y9

Cert. Date	Cert. No.	Sales Order	Page
12/14/05	132184	78944	1
Cust. PO	B/I. No.	Lot	Date
173	00287984	78944010	12/14/05

Sold To	Ship To
48024 DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7	48024 DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7

Item No	Part No	Item Description	Cust Part
1.000	DAA-897121-2	240" Mill 6061 T6	D2600-1-240
Gross Weight	605 KGS		
Net Qty	570 KG	59 PC	360 M 1 PKG

Specification	Die Desc
AMS-QQ-A-200/8 & ASTM B221-00	

Mechanical Tests:

Test No.	Tensile MPA / KSI	Yield MPA / KSI	%Elongation	Conductivity	Bend/ Drift HR-E
1	320.0 / 46.4	291.8 / 42.3	14.3		92

Chemical Analysis:

SI	FE	CU	MN	MG	CR	NI	ZN	GA	V	TI	ZR	OTHER
.669	.306	.272	.065	.905	.067	.000	.121	.000	.010	.017	.000	.000
.646	.276	.260	.076	.863	.061	.000	.013	.000	.010	.017	.000	.000
.000	.000	.000	.000	.000	.000	.000	.000	.000	.000	.000	.000	.000
.000	.000	.000	.000	.000	.000	.000	.000	.000	.000	.000	.000	.000

This will certify that the material described herein has been inspected and tested in accordance with Bon L Canada's standard sampling and testing procedures or in accordance with the requirements of any specifications forming a part of the material description to the extent indicated herein. Data of chemical composition for the material and test results from samples representative of the material are set forth above hereof or in any attachments hereto. This information shows that the material meets the applicable requirements. Inspection and test records are maintained on file. This certificate shall be deemed apart of and subject to the terms and conditions of warranty set forth on the reverse side of our order acknowledgement form. No other warranties are applicable.

Ritchie Bisnauth, QA Manager Signed for Bon L Canada